

Date: Wednesday, 1/31/2007 2:38:46 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: RADIUS BLOCK		
Job Number	: 30518		Part Number	: D2274		
Estimate Number	: 10822		Drawing Number	: D2274 REV F		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 1/31/2007	S.O. No. : N/A	Drawing Revision	: F		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 2/15/2007		
Previous Run	: 30380		Qty:	500	Um:	Each
Written By	:		Comment	: Est. H 00.05.18 Added inspection level 8 EC		
Checked & Approved By	:		Signature: 07.02.01			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0750X00125	6061-T6 Bar .75" x .125" <i>0462</i> <i>49836</i>
Comment: Qty.: 0 f(s)/Unit Total : 48 f(s) 6061-T6 Bar .75" x .125" Material: 6061-T6 (QQ-A-250/11) or 5052-H34 (QQ-A-250/8) 1/8" X 3/4" BarBatch <i>M103503</i> <i>M103433</i> <i>1234</i>		
2.0	SHEAR	SHEAR
Comment: SHEAR Shear blanks 9.00" long +/- 0.030" Note: 1 blank makes 9 pieces <i>07.02.12</i> <i>578</i>		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio D2274 <i>07.02.12</i> <i>578</i>		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>07.02.12</i> <i>578</i>		
5.0	QC8	SECOND CHECK
Comment: SECOND CHECK <i>07.02.18</i> <i>578</i>		
6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 Tumble Deburr any rough edges after tumbling <i>07.02.27</i> <i>578</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval- Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 01/03/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Ed/AN

07/02/28

518

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Epas/03/05

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Epas/03/05 516 *h*

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Epas/03/06 516

Job Completion



Epas/03/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30518
Description: Radius Block	Part Number:	D2274
Inspection Dwg: D2274	Rev: F	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

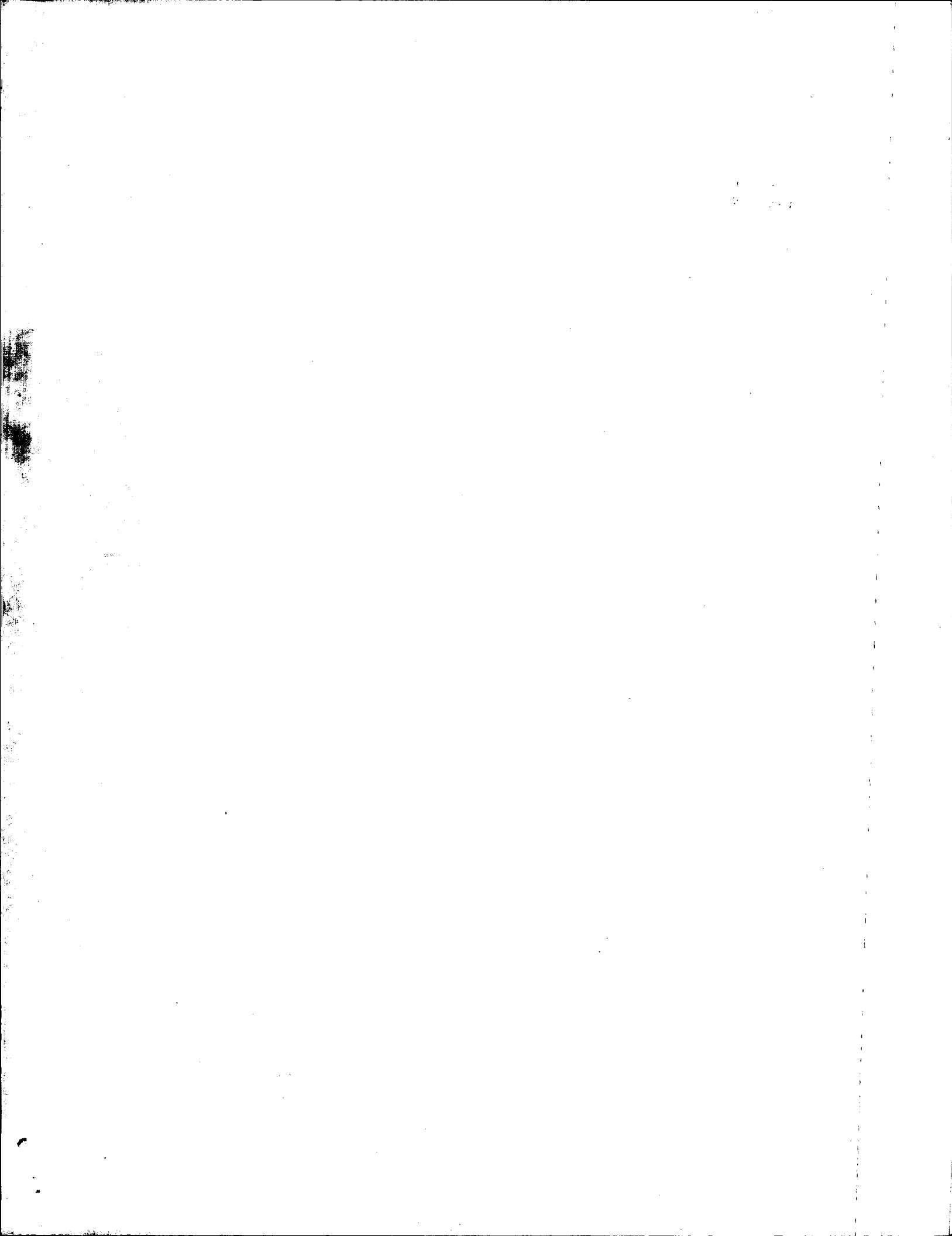
X First Article Prototype

Measured by: SD
Date: 01.02.12

Audited by:	<i>Amber</i>
Date:	07/02/18

Prototype Approval:	
Date:	

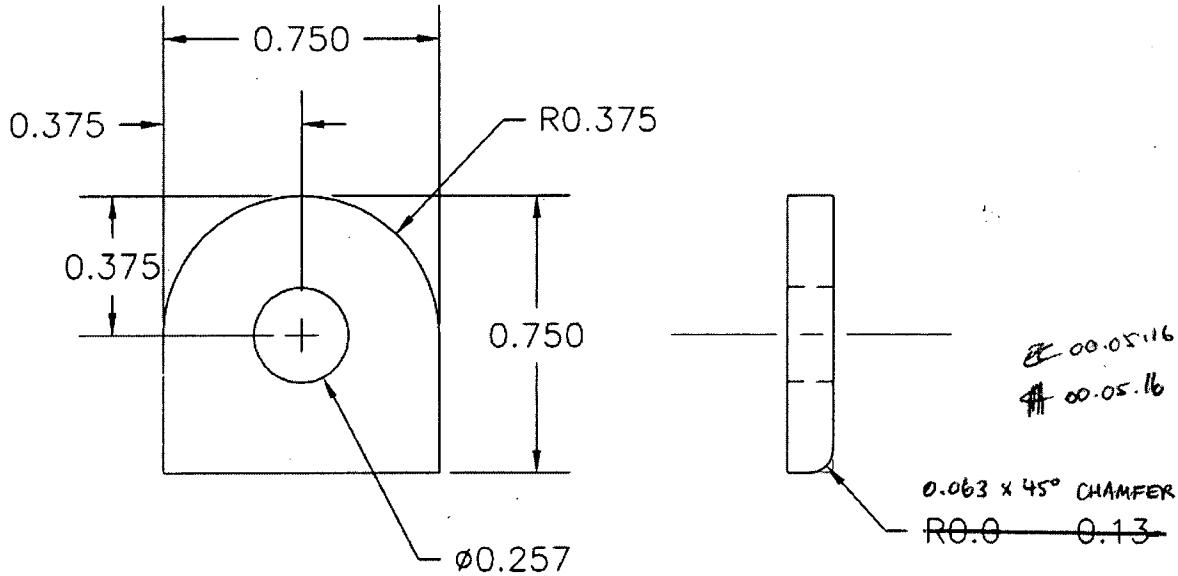
Rev	Date	Change	Revised by	Approved
A	03.10.07	New Issue	KJ/RF	





DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2274
DATE		TITLE RADIUS BLOCK
98.08.11		SCALE 2:1
A	94.09.29	NEW ISSUE
C	95.07.12	RADIUS ENDS
D	97.03.24	ADD MATERIAL SPECIFICATION
E	97.12.12	ADD FINISH & TOLERANCE QSI
F	98.08.11	R0.0 - 0.13 WAS R0.063 - 0.125

RELEASED
98/08/18 KG



MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK
OR 6061-T6 (QQ-A-250/11) 0.125 THICK

FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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WITHOUT NOTICE

606116
M 1C 3503
160 A. 125